

Date: Thursday, 5/31/2007 7:20:07 AM
User: Kim Johnston

Process Sheet

split
5607106/11
24

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : HELI-ACCESS STEP LH (FOLDING)
Job Number : 32713	
Estimate Number : 12567	
P.O. Number : <i>NA</i>	Part Number : D412630033
This Issue : 5/31/2007 S.O. No. : <i>NIA</i>	Drawing Number : IIN D412-630 REV K
Prsht Rev. : NC	Project Number : N/A
First Issue : <i>NIA</i> Type : LARGE FAB ASSY	Drawing Revision : K
Previous Run : 31459	Material : <i>NA</i>
Written By : <i>JA 07.05.31</i>	Due Date : 6/11/2007 Qty: 3 Um: Each
Checked & Approved By : <i>JA 07.05.31</i>	
Comment : Est. Rev:A New Issue 06-11-08 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	DC	DOCUMENT CONTROL
-----	----	------------------



Comment: DOCUMENT CONTROL
Photocopy bluefile & create labels per PPP D412-630-033 CHG002

2.0	D2012107	Clevis
-----	----------	--------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Clevis

Pick:

Qty	Part Number	Description	Batch
1	D2012-107	Clevis	<i>B29653</i>

3.0	D2803041	Bracket Assembly
-----	----------	------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Bracket Assembly

Pick:

Qty	Part Number	Description	Batch
1	D2803-041	Bracket Assembly LH	<i>B29391</i>

4.0	D2804041	Bracket Assembly
-----	----------	------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Bracket Assembly

Pick:

Qty	Part Number	Description	Batch
1	D2804-041	Bracket Assembly LH	<i>B27102</i> <i>B27284</i>

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
07/06/11	18	split w/o	SB	07/06/11	1		

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI-ACCESS STEP LH (FOLDING)

Job Number: 32713

Part Number: D412630033

Job Number:



Seq. #:

Machine Or Operation:

Description:

5.0

D2807

Support Prop



Comment: Qty.: 2.0000 Each(s)/Unit Total: 10.0000 Each(s)

Support Prop

Pick:

Qty Part Number

Description

Batch

2 D2807

Gas Spring

1528488

6.0

D2813

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total: 10.0000 Each(s)

Washer

Pick:

Qty Part Number

Description

Batch

2 D2813

Washer

1325923

7.0

D3562041

STEP ASSEMBLY, LH



Comment: Qty.: 1.0000 Each(s)/Unit Total: 5.0000 Each(s)

Step Weldment LH

Pick:

Qty Part Number

Description

Batch

1 D3562-041

Step Weldment LH

B 32718
1325923

8.0

D33951

Bushing



Comment: Qty.: 4.0000 Each(s)/Unit Total: 20.0000 Each(s)

Bushing

Pick:

Qty Part Number

Description

Batch

4 D3395-1

Bushing

1327291

9.0

AN3C21A

BOLT



Comment: Qty.: 2.0000 Each(s)/Unit Total: 10.0000 Each(s)

BOLT

Pick:

Qty Part Number

Description

Batch

2 AN3C21A

Bolt

①
1419633

14101189

52

7/6/454

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI-ACCESS STEP LH (FOLDING)

Job Number: 32713

Part Number: D412630033

Job Number:



Seq. #:

Machine Or Operation:

Description :

10.0

AN8C16

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Bolt

Pick:

Qty Part Number

Description

Batch

2

AN8C16

Bolt

3x
18 779

4x
M100695

11.0

AN310C8

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Nut

Pick:

Qty Part Number

Description

Batch

2

AN310C8

Nut

3x
M100433

3x
M102728

12.0

MS24665302

Cotter Pin



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Cotter Pin

Pick:

Qty Part Number

Description

Batch

2

MS24665-302

Cotter Pin (or AN380C3-4)

M16941

13.0

NAS1515H3

Washer



Comment: Qty.: 6.0000 Each(s)/Unit Total : 30.0000 Each(s)

Washer

Pick:

Qty Part Number

Description

Batch

6

NAS1515H3

Washer

6x
M19633

12x
M100993

14.0

NAS1515H5L

WASHER



Comment: Qty.: 4.0000 Each(s)/Unit Total : 20.0000 Each(s)

WASHER

Pick:

Qty Part Number

Description

Batch

4

NAS1515H5L

Washer

10x
M101925

2x
M103286
2/6/450

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI-ACCESS STEP LH (FOLDING)

Job Number: 32713

Part Number: D412630033

Job Number:



Seq. #:

Machine Or Operation:

Description:

15.0

NAS1515H8

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total: 20.0000 Each(s)

Washer

Pick:

Qty	Part Number	Description
4	NAS1515H8	Washer

Batch

M102067

16.0

MS210433

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total: 20.0000 Each(s)

Nut

Pick:

Qty	Part Number	Description
4	MS21043-3	Nut

Batch

M103286

M103691

17.0

MS24693C280

Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total: 10.0000 Each(s)

Screw

Pick:

Qty	Part Number	Description
2	MS24693-C280	Screw (or MS24694-C565)

Batch

M101390

7/6/450

18.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per dwg D412-630 p.14

Coat all hardware with LPS3 rust inhibitor

A/R LPS3 batch: M101472

COAT exposed HARDWARE WITH LPS PROCYON.

A/R LPS PROCYON

BATCH: M101475

MA 01-06-12 ①

19.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SB 27/06/12 ①

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI-ACCESS STEP LH (FOLDING)

Job Number: 32713

Part Number: D412630033

Job Number:



Seq. #:

Machine Or Operation:

Description :

20.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

21.0

D28061

Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Bushing

Pick: Packing Kit

Qty Part Number

2 D2806-1

Description

Bushing

Batch

1327285

1328162

1329393

22.0

D28063

Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Bushing

Pick: Packing Kit

Qty Part Number

2 D2806-3

Description

Bushing

Batch

1328163

1329394

23.0

D28105

Strut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Strut

Pick: Packing Kit

Qty Part Number

1 D2810-5

Description

Strut

Batch

1327287

1328103

24.0

D33961

Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Spacer

Pick: Packing Kit

Qty Part Number

2 D3396-1

Description

Spacer

Batch

1327290

25.0

AN4C6A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Bolt

Pick: Packing Kit

Qty Part Number

Description

Batch

M102039

7/6/4 SP

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI-ACCESS STEP LH (FOLDING)

Job Number: 32713

Part Number: D412630033

Job Number:



Seq. #:

Machine Or Operation:

Description :

1 AN4C6A Bolt

26.0

AN4C10A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Bolt

Pick: Packing Kit

Qty Part Number

Description

Batch

1 AN4C10A

Bolt

M100273 ✓

27.0

AN4C15A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Bolt

Pick: Packing Kit

Qty Part Number

Description

Batch

2 AN4C15A

Bolt

M101291 ✓

28.0

AN44C7A

Eyebolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Eyebolt

Pick: Packing Kit

Qty Part Number

Description

Batch

1 AN44-C7A

Eyebolt

M19620 M101711 1X ✓

29.0

AN5C15A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Bolt

Pick: Packing Kit

Qty Part Number

Description

Batch

2 AN5C15A

Bolt

M100229 ✓

30.0

NAS1515H4

Washer



Comment: Qty.: 7.0000 Each(s)/Unit Total : 35.0000 Each(s)

Washer

Pick: Packing Kit

Qty Part Number

Description

Batch

7 NAS1515H4

Washer

M101429 ✓ 7/6/4 50

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI-ACCESS STEP LH (FOLDING)

Job Number: 32713

Part Number: D412630033

Job Number:



Seq. #:

Machine Or Operation:

Description:

31.0

NAS1515H5

Washer



Comment: Qty.: 7.0000 Each(s)/Unit Total: 35.0000 Each(s)

Washer

Pick: Packing Kit

Qty Part Number

7 NAS1515H5

Description

Washer

Batch

M101925

19

M102728

32.0

MS210434

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total: 20.0000 Each(s)

Nut

Pick: Packing Kit

Qty Part Number

4 MS21043-4

Description

Nut

Batch

M104537

33.0

MS210435

Nut



Comment: Qty.: 3.0000 Each(s)/Unit Total: 15.0000 Each(s)

Nut

Pick: Packing Kit

Qty Part Number

3 MS21043-5

Description

Nut

Batch

M101419

7/6/4

EP3

34.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

7/6/12 (1)

C207106112-1

35.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D412-630-033

Location:

PPP Rev:

Rev 0

7/6/12 250

C207106112-1

36.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

7/6/12 (1)

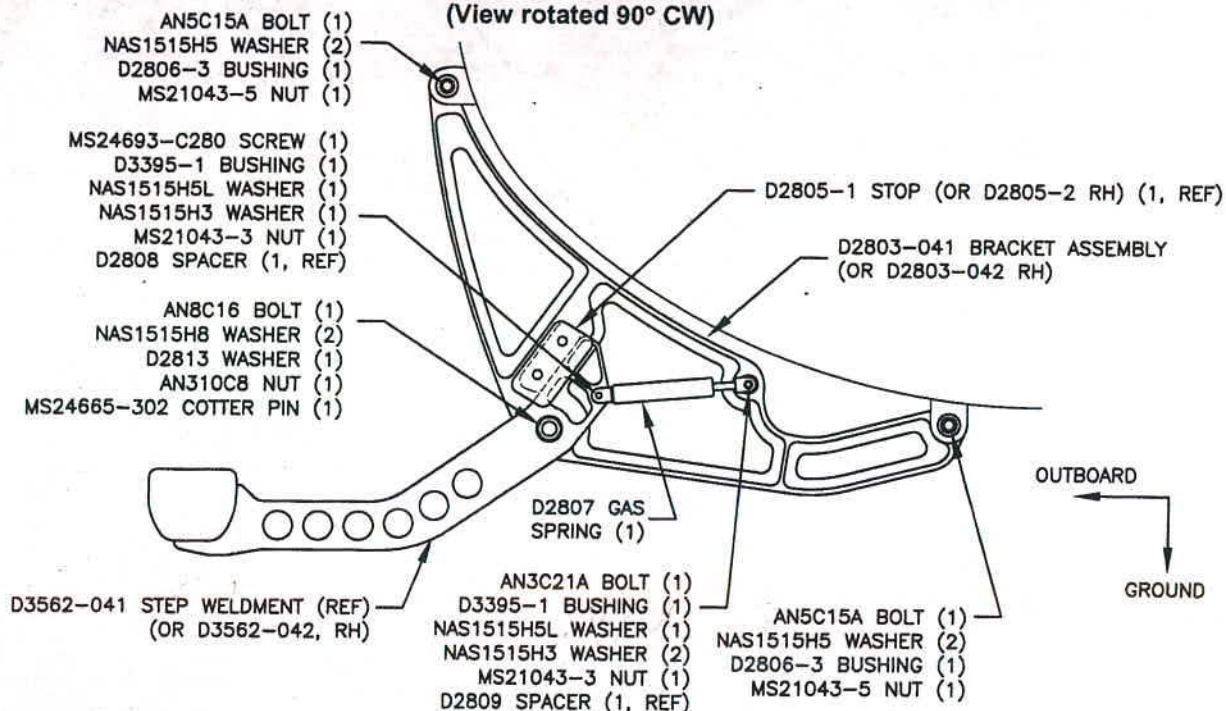
Job Completion



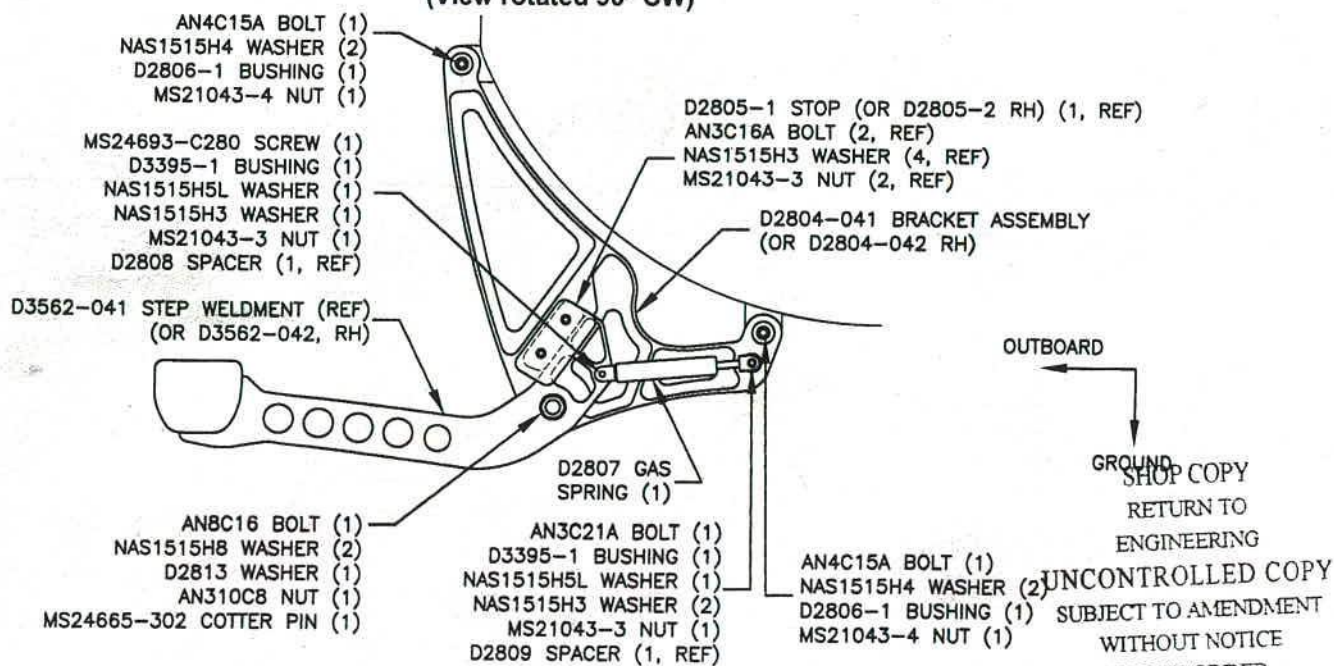
W 07/06/12

D412-630-033/-034 Heli-Access-Step™ Installation**FIGURE 14 – STA 84.29 for D412-630-033/-034 Heli-Access-Step™ Installation**

(View rotated 90° CW)

**FIGURE 15 – STA 155.06 for D412-630-033/-034 Heli-Access-Step™ Installation**

(View rotated 90° CW)



SHOP COPY

RETURN TO

ENGINEERING

UNCONTROLLED COPY

SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER

NO. 32713

• COPYRIGHT © 1996 BY DART AEROSPACE LTD. •

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

Revision: K

Date: 06.10.05